

INCH-POUND

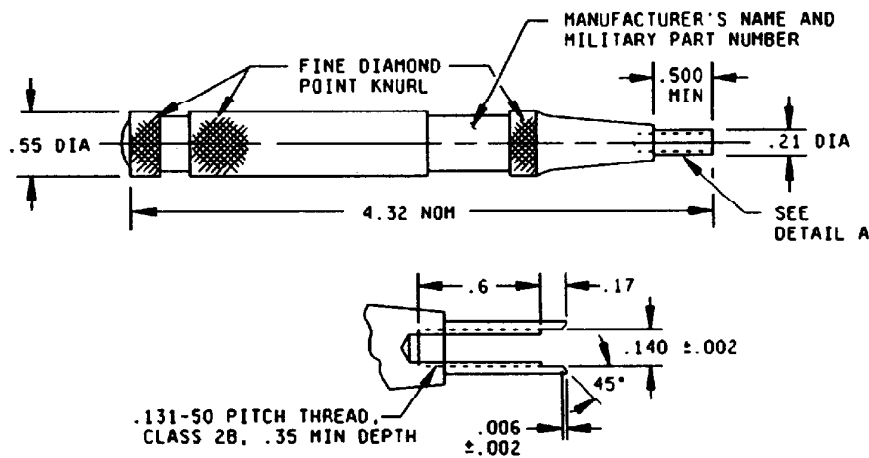
MIL-I-81969/45A(USAF)
28 June 1993
SUPERSEDING
MIL-I-81969/45(USAF)
29 January 1982

MILITARY SPECIFICATION SHEET

INSTALLING TOOL, SOLDERLESS SPRING CONTACT, TYPE I, COMPOSITION A

This specification is approved for use by the Air Force Acquisition Logistics Division, Directorate of Electronic Support (AFALD/PTS), Gentile AFS, Ohio 45444, Department of the Air Force, and is available for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and the issue of the following specification listed in that issue of the Department of Defense Index of Specifications and Standards (DODISS) specified in the solicitation: MIL-I-81969.



Inches	mm	Inches	mm	Inches	mm
.0010	.03	.060	1.52	.20	5.1
.002	.05	.065	1.65	.21	5.3
.003	.08	.07	1.8	.37	9.4
.0045	.110	.093	2.36	.500	12.70
.005	.13	.100	2.54	.55	14.0
.006	.15	.131	3.33	.6	15.25
.010	.25	.140	3.56	.70	17.8
.042	1.07	.17	4.3	4.32	109.7
.050	1.27	.187	4.75		

FIGURE 1. Handle and installation tips.

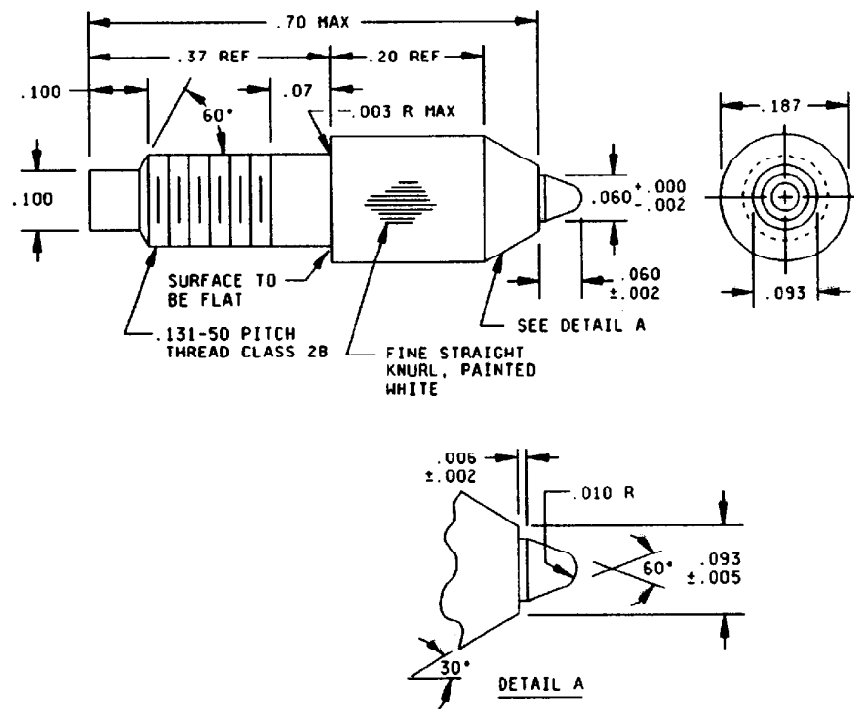
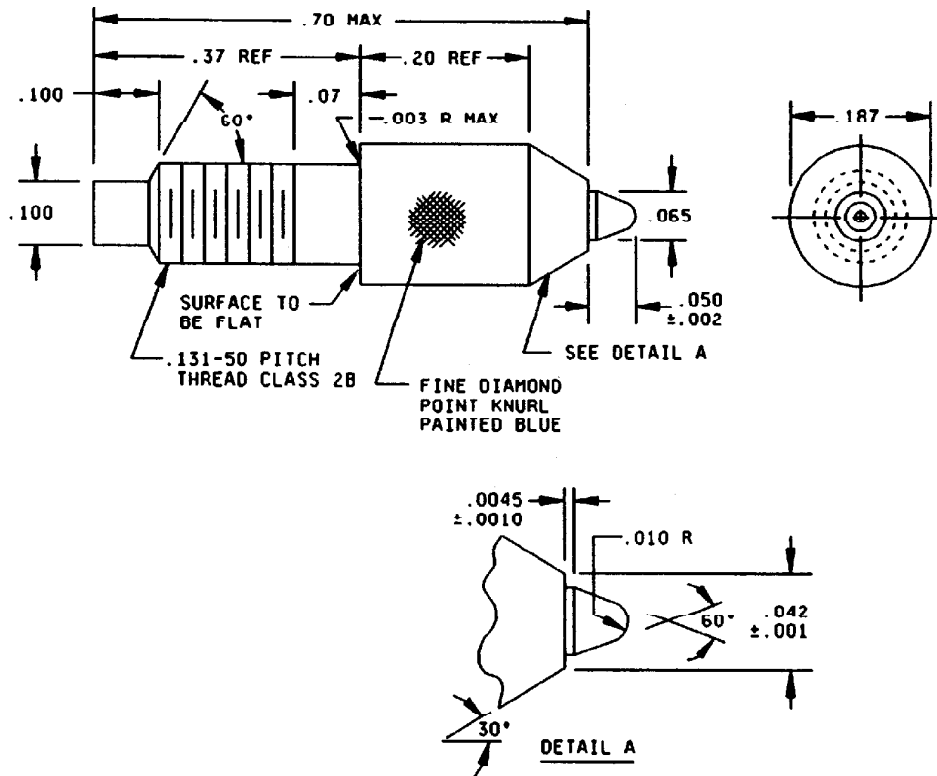


FIGURE 1. Handle and installation tips - Continued.

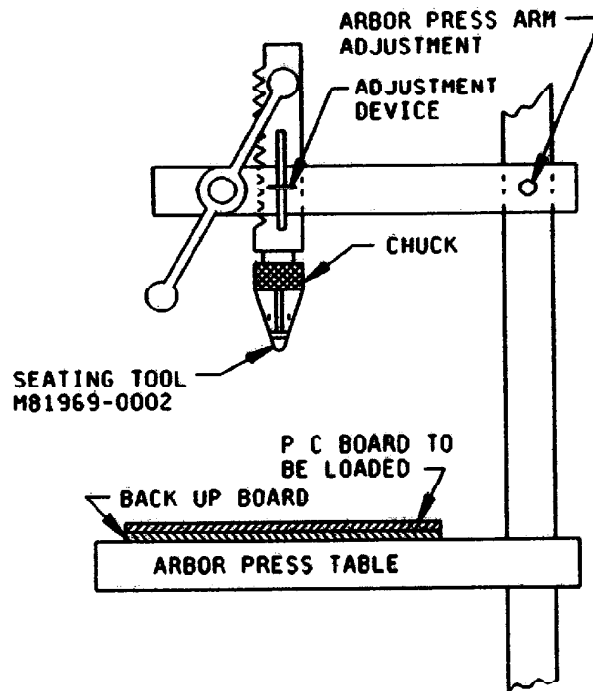


Installation tip - 0003

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for general information only.
3. Unless otherwise specified, tolerance is ± 0.005 inch (0.13 mm) for three place decimals and ± 0.02 inch (0.5 mm) for two place decimals.
4. Marking: Handle is to be marked with manufacturer's name and military part number (M81969/45-0001), as a minimum. The tip being too small is to be marked properly, shall be supplied in an envelope which shall be marked with manufacturer's name and military part number (as a minimum) and color coded, as shown.

FIGURE 1. Handle and installation tips - Continued.



NOTES:

1. Insert M81969/45-002 tip into the drill chuck of the arbor press. Tighten chuck onto tip.
2. Place PC board, which is to have contacts installed on its back-up board, with receiving surface of PC board facing towards installation tip.
3. Place PC board and back-up board under installation tip.
4. Lower installation tip to PC board until a flush fit is accomplished; tip should be snug with contacts.
5. Set the arbor press to permit pressure on socket to extend from snug point to fully seated position.
6. Use pressure exerted by arbor press thru tip, to socket, to seat socket, as required.

FIGURE 2. Installation procedure, using MIL-I-81969/45-002 installation tip and arbor press to install MIL-S-83505/6-004 sockets in board.

REQUIREMENTS:

Dimensions and configuration: See figure 1.

Installation procedure: See figure 2.

Materials:

Handle: AISI-C12L14 steel.

Plunger shaft (tapped): AISI-W1 (hardened) steel.

Installation tips (-002 and -003): AISI-01 tool steel, double draw.

Plating: Handle (exterior only): Chrome plate (0.0002-0.0005 inch thick) dull.

-0002 tip: Chrome plate .00005 inch minimum.

-0003 tip: Chrome plate .00005 inch minimum.

Hammer triggering force: 7 pounds minimum (spring loaded).

Rotation: Not applicable.

Thrust: Not applicable.

Application: These tools shall be used to install MIL-S-83505/6 sockets as follows:

To install a M83505/6-001 socket, use the handle (M81969/45-001) and installation tip (M81969/45-0003) assembled.

To install a M83505/6-002 or /6-003 socket, use the handle (M81969/45-001) and installation tip (M81969/45-0002) assembled.

To install a M83505/6-004 socket, use the handle (M81969/45-002) and arbor press: See drawing and installation procedure on page 4.

Qualifications is not required.

First article inspection shall be applied on each and every contract. The first article inspection shall not be waived even for manufacturers who have previously received a first article inspection contract. Contracts with renewal options shall impose first article test requirements at each renewal.

The first article test requirements are as specified in MIL-C-81969, paragraph 4.4, qualification inspection, for each dash number. The only approved laboratory shall be as follows:

Naval Air Warfare Center
Aircraft Division (DP704N/MS-60)
6000 East 21st Street
Indianapolis, IN 46219-2189
Telephone 317-353-3274

The bidder awarded the contract shall incur the costs of first article tests. The contracting officer shall include a fee schedule identifying the cost for first article testing in the contract solicitation. The fee schedule shall be obtained from the Naval Air Warfare Center.

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CONCLUDING MATERIAL

Custodian:
Air Force - 85

Review activities:
Air Force - 99
DLA - ES

Preparing activity:
Air Force - 85

Agent:
DLA - ES

(Project 5120-F002)